



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBW6305G25131-3G

Job Sheet 192244



Part No: RBW6305G25131-3G

Job Qty: 1 pcs

Part Name: Tool, Input Pinion Mating Ring Replacement



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/20/19

Job Tracking No:

Due Date: 5/29/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 6629*

Note: DWG RBW6305G25131-3G Rev.1 IPP Rev. A 18.10.18 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	5/29/19		0.00	0.00	Small Fab - 1		<i>MLL</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	5/29/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	1 pcs	5/29/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 28 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Container No: S183845



Part: RBW6305G25131-3G

Job No: 192244

Serial No/Batch: S183845

Revision: 1

Inspector:

Exp Date:

Instructions:

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1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/24/19

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				Packaging 3 - 8 - B4B					
				Packaging 3 - 9 - B4B					
				Packaging 3 - 10 - B4B					
				Packaging 3 - 11 - B4B					
				Packaging 3 - 12 - B4B					
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B					
				Packaging 3 - 23 - B4B					
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B					
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B					
				140 QC 21 - FG	1 pcs	5/29/19	0.00 0.00	QC 21 - FG - 21	DAS
								QC 21 - FG - 70	21
								QC 21 - SA - 53	9-10
									MAY 27 2019

Part Op 110 - (Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Descriptions: Pelican case APP-1400-E 3-Debur holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW6305G25131-3G-5 to RBW6305G25131-3G-3 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	110-Small Fab - 1	5145165
APP-1400-E	Case	1 Ea (1 ea)	110-Small Fab - 1	5170735
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab - 1	5021040
RBW6305G23631-3G - PO	Tool, Input Pinion Mating Ring Remover	1 Ea (1 ea)	110-Small Fab - 1	5173951
RBW6305G23731-3G - PO	Tool, Input Mating Ring Installation	1 Ea (1 ea)	110-Small Fab - 1	5173936
RBW6305G25131-3G-1	Bottom Foam use in case APP-1400-E	1 Ea (1 ea)	110-Small Fab - 1	5170731
RBW6305G25131-3G-3	Top Foam use in case APP-1400-E	1 Ea (1 ea)	110-Small Fab - 1	5170732
11 - 5 PLACARD		①		5164961

Job Allocations

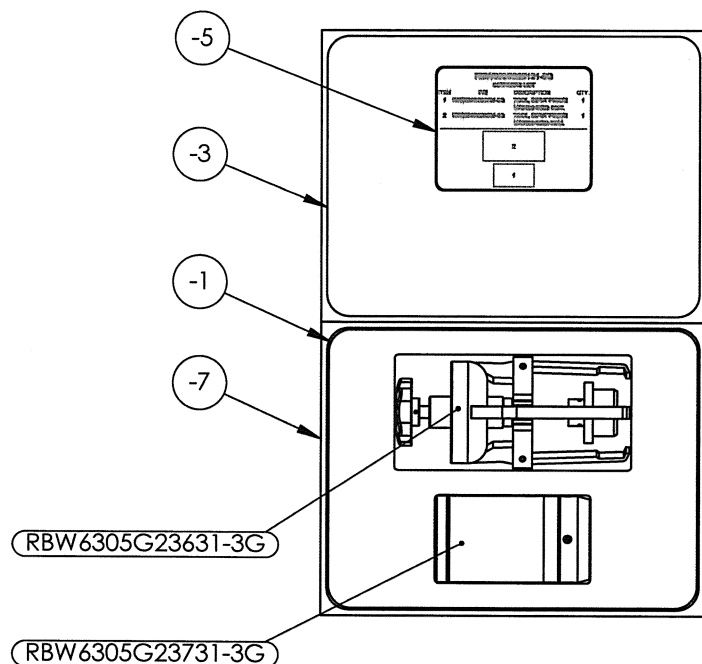
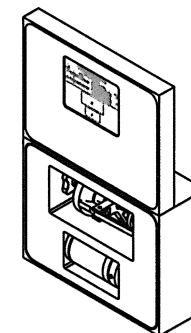
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	97524A032	4	413	0
	APP-1400-E	1	9	0
	RB41011	1	374	0
	RBW6305G23631-3G	1	0	0
	RBW6305G23731-3G	1	0	0
	RBW6305G25131-3G-1	1	0	0
	RBW6305G25131-3G-3	1	0	0

Part Specifications
Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	5/19/2017	RJC	JAG



NOTE:
REFERENCE AGUSTA T/N 3G6305G25131.

DART AEROSPACE																	
TITLE TOOL KIT, INPUT PINION MATING RING REPLACEMENT																	
DWG NO. RBW6305G25131-3G	REV 1																
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT TREAT</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>FINISH</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td>SPEC</td> <td>.XX ± .01 ANGLES ± 5°</td> </tr> <tr> <td></td> <td>.X ± .1 SURFACES = 125/</td> </tr> <tr> <td colspan="2"> 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 </td> </tr> <tr> <td colspan="2">USED ON MODEL</td> </tr> <tr> <td colspan="2">AW139</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	HEAT TREAT	DIMENSIONS ARE IN INCHES	FINISH	.XXX ± .005 FRACTIONS ± 1/8	SPEC	.XX ± .01 ANGLES ± 5°		.X ± .1 SURFACES = 125/	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009		USED ON MODEL		AW139	
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DRAWN BY: RJC 05/19/2017 CHECKED: DD 05/22/2017 OPPTS APPR: AA 06/05/2017 QA APPR: JL 06/13/2017 APPROVED: JAG 06/15/2017	SCALE 1:6 DATE 5/19/2017 SHEET 1 OF 4																

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	TOOL, INPUT PINION MATING RING REMOVER		RBW6305G23631-3G	1
				1	TOOL, INPUT PINION MATING RING INSTALLATION		RBW6305G23731-3G	1
		B/O	-1	1	BOTTOM FOAM	ETHAFOAM 220, BLACK	3.95 X 9.08 X 11.98 (CASE SOLUTIONS)	2
		B/O	-3	1	TOP FOAM	ETHAFOAM 220, BLACK	1.20 X 9.20 X 12.10 (CASE SOLUTIONS)	3
			-5	1	CONTENT PLACARD	PLASTIC		4
		B/O	-7	1	CASE	PLASTIC	PELICAN #APP-1400-E	1
		B/O		1	DART PLACARD	ALUMINUM	RB41011	N/S

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					